



WB17-4 PH MIG WELDING WIRE

SPECIFICATIONS	AWS A5.9: ER630									
PRODUCT DESCRIPTION	Solid MIG wire for the welding of 17/4 PH alloys.									
APPLICATION	This grade is a precipitate hardening grades of stainless steel, containing 17%Cr / 4%Ni and used for welding similar material of the ARMCO 17-4PH type.									
TYPICAL ALL-WELD METAL COMPOSITION (Wt. %)	C	Mn	Si	Cr	Ni	Mo	Cu	Nb		
	0.05 max.	0.25 0.75	0.75 max.	16.00 16.75	4.5 5.0	0.75 max.	3.25 4.00	0.15 0.30		

TYPICAL PWHT WELD METAL MECHANICAL PROPERTIES	Ultimate Tensile Strength	MPa	>930
	Yield Stress/0.2% Proof Stress	N/mm ²	-
	Elongation on 4D	%	7
	Charpy Vee Impact @	Joules	-

ADDITIONAL INFORMATION

SHIELDING GAS	98%Ar, 2%O ₂ ,
CURRENT CONDITION:	DC+
AVAILABLE SIZES:	1.0, 1.2mm

Current Conditions DC+ and Welding Positions

